

54735 DREV

Work Order ID 52796

October 14, 2009 10:46:10 AM



Page 1

Item ID: D3391-025

Accept



Setup Start



Revision ID: H

Stop



Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *RR*

Date: *10-14*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	Rev H								

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599

Rev: *AA* & Dwg D3391 Rev: *H*

Q.A. 09-10-270

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Q.A. 09-10-270

111

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

22 8/10/08

Q.A. 09

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Item ID: D3391-025

Accept

Revision ID: H

Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00

Required Date: 02/11/2009 Req'd Qty: 1.00




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Machine as per Folio FA 599 Rev: <u>H</u> & Dwg D3391 Rev: <u>H</u> <u>SL</u> 09/11/16 2-Deburr	0.00 0.00				<u>1</u>	<u>0</u>		
130  QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				<u>1</u>	<u>0</u>		
140  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>1</u>	<u>0</u>		

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Item ID: D3391-025

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Setup Start



Revision ID: H

Stop



Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Skidtubes	Skidtubes	0.00						MB 09-11-19	
Skidtubes	Memo	0.00							
Skidtubes	1-Drill (PILOT HOLE) aft cap holes per Dwg D3391 using DT8803								
160 CNC Bend 1 CNC Delta 100 Bender	BENDING MACHINE - SKIDTUBES	0.00				1	11/11/1		
	Memo	0.00							
	Form as per Dwg D3391 Using Bend Prog 3391025								
									$h = 4.060''$
									$h^\circ = 4.6^\circ$
170 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00					f		
									\rightarrow S016123

Work Order ID 52796

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Item ID: D3391-025

Accept



Setup Start



Revision ID: H

Stop



Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217
Wearplate Jig .

*****Do Not Open To Finished Size*****

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2
previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe , wearplate to 0.297"and float bag holes to 0.328" as per
Dwg D3391.

7-Deburr

1 9/11/23

Ph →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-025 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 7 Date: 09.12.30
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>52796</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.12.11	180	DEEP PITTING FOUND FOUND ON INNER WALL AT AFT TUBE. AREA WAS GROUND. AREA NOW SMOOTH BUT WALL IS 0.058" IN THE AFFECTED AREA.	CP 09.12.11 PC QSI 042	Acceptable. Area 2 2"x3" IN NON-STRUCTURAL AFT PART OF TUBE.	H 9/12/11	S 09/12/16	CP 09.12.11 PC QSI 042	S 09/12/16
		R.C. Slight surface imperfection						

NOTE: Date & initial all entries

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Item ID: D3391-025

Accept



Setup Start



Revision ID: H

Stop



Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 02/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	278 or 1/23						
200 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	19/12/15		
210 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				①		BE 09/12/15	

Work Order ID 52796

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Item ID:	D3391-025	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	Aft Tube Assembly					
Start Date:	14/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	02/11/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220 Skidtubes	Skidtubes	0.00							
Skidtubes	Memo Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>M 112417</u> exp. date: <u>11/1/11</u> cure time 12hrs as per QS10015	0.00							
230 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
240 Powdercoat	White Gloss (Ref: 4.3.5.1) per QS1005 4.3-Alum	0.00							
Powder Coating	Memo START TIME: <u>3:40</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>4:10</u>	0.00							

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Item ID: D3391-025

Accept

Revision ID: H

Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00

Required Date: 02/11/2009 Req'd Qty: 1.00




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	⇒ 24 09-12-12			(X1)	0		
260  HandFinish Hand Finishing	HandFinishing Memo ✓ 1-Install inserts as per Dwg D3391 ✓ 2-Install Aft Cap as per Dwg D3391 A/R Sikaflex-241/-291 M1112345 — Sikaflex expiry date: 10/08	0.00 0.00	⇒ 24 09-12-17			(X1)	0		
270  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	⇒ 8 09/12/17			(X1)			

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Item ID: D3391-025

Accept

Revision ID: H

Item Name: Aft Tube Assembly

Start Date: 14/10/2009 Start Qty: 1.00

Required Date: 02/11/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280



Packaging

Packaging

Identify as per dwg & Stock Location: B52785

0.00

Memo

4/0 52785

0.00

→ HJ 09-12-17400

290



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/12/18 HJPR 09/12/17 ①

Picklist Print

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Page 1

Work Order ID: 52796

Parent Item: D3391-025RevH

Parent Item Name: Aft Tube Assembly

Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6014-090RevA		Manufactured	No			100	Each	21.0000	1.0000			
ALUMINUM EXTRUSION												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

21

42768

21

D3670-4-200RevA

Manufactured

No

230

Each

163.0000

4.0000

SPACER

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

163

46106

4

47122

32

48198

42

48269

85

19/12/15

Picklist Print

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Work Order ID: 52796



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2646RevC 		Manufactured	No			270	Each	55.0000	1.0000			
Aft Cap												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

55

20208

0

43801

1

46327

6

48109

48

xl Jul 09-12-17

D3537-1RevC

Manufactured No



270

Each

199.0000

1.0000

Wearpad



Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

2

48288

2

Main Warehouse

FP17

162

51678

162

Main Warehouse

ST

35

51918

35

xl Jul 09-12-17

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Shop Packet Print

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Picklist Print

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Work Order ID: 52796



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3537-7RevC

Manufactured

No

270

Each

23.0000

1.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

23

45408

9

46346

14

D3553-1RevA

Manufactured

No

270

Each

18.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

33868

18

D3553-3RevA

Manufactured

No

270

Each

7.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7

47206

7

xl 09-12-17

xl 09-12-17

xl 09-12-17

Picklist Print

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Work Order ID: 52796



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly


Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-1RevB  Phenolic Washer		Manufactured	No			270	Each	2,060.000	2.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1560

39275

19

42329

19

47628

522

52505

1000

Main Warehouse

ST117

500

51674

500

ALS4-1032-130

Purchased

No

260

Each

5,373.000

14.0000



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

5373

110511

5373

1111529

Y1 M 09-12-17

October 14, 2009 10:46:18 AM

Shop Packet Print

Page 4

Picklist Print

October 14, 2009 10:46:18 AM

Work Order ID: 52796

Parent Item: D3391-025RevH

Parent Item Name: Aft Tube Assembly

Comments:

Start Date: 14/10/2009

Required Date: 02/11/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			270	Each	7,911.000	12.0000			



Insert

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

7911

107441

16

10768

7895

AN3C4A

Purchased

No

270

Each

2,216.000 6.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2216

112082

14

112314

40

112720

162

112724

500

112794

1000

112829

500

X 12 M 09-12-17

X 6 M 09-12-17

Picklist Print

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Work Order ID: 52796



Parent Item: D3391-025RevH



Parent Item Name: Aft Tube Assembly

Start Date: 14/10/2009

Required Date: 02/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C5A 		Purchased	No			270	Each	718.0000	4.0000			
Bolt												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	718	
111424	8	
111707	69	
112314	11	
112489	100	
112641	500	
112720	30	

x4 M 09-12-17

AN960C10L



washer

Purchased

No

270

Each

4,772.000 10.0000



Warehouse Loc Qty Loc Code
Location

OFFSHORE

FG	100	
103585	100	

Main Warehouse

ST	4672	
112116	1009	
112612	3663	

NAS149C0332R / M113288 x10 M 09-12-17

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Shop Packet Print

Page 6

DART AEROSPACE LTD		Work Order:	52796
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: H	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.010	/			
3.500	+/-0.010	3.494	/			
88.93	+/-0.030	88.940	/			
44.995	+/-0.030	44.965	/			
Ø3.200	+/-0.010	3.200	/			
88.93	+/-0.030	88.940	✓			
Ø3.750	+/-0.010	3.751	✓			
30° x 160" chamfer	+/-0.010	30° x 160"	/			

Measured by:	Q.m	Date:	09-10-28
Audited by:	Q.m	Date:	09/10/28

HAAS Section						
1.526	+0.000/-0.030	1.516	✓			
0.200	+/-0.010					
7.500	+/-0.010	7.498	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.305	✓			
0.200	+/-0.010	.203	✓			
3.520	+/-0.010	3.519	✓			
0.687	+0.010/-0.000	.690	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.485	✓			

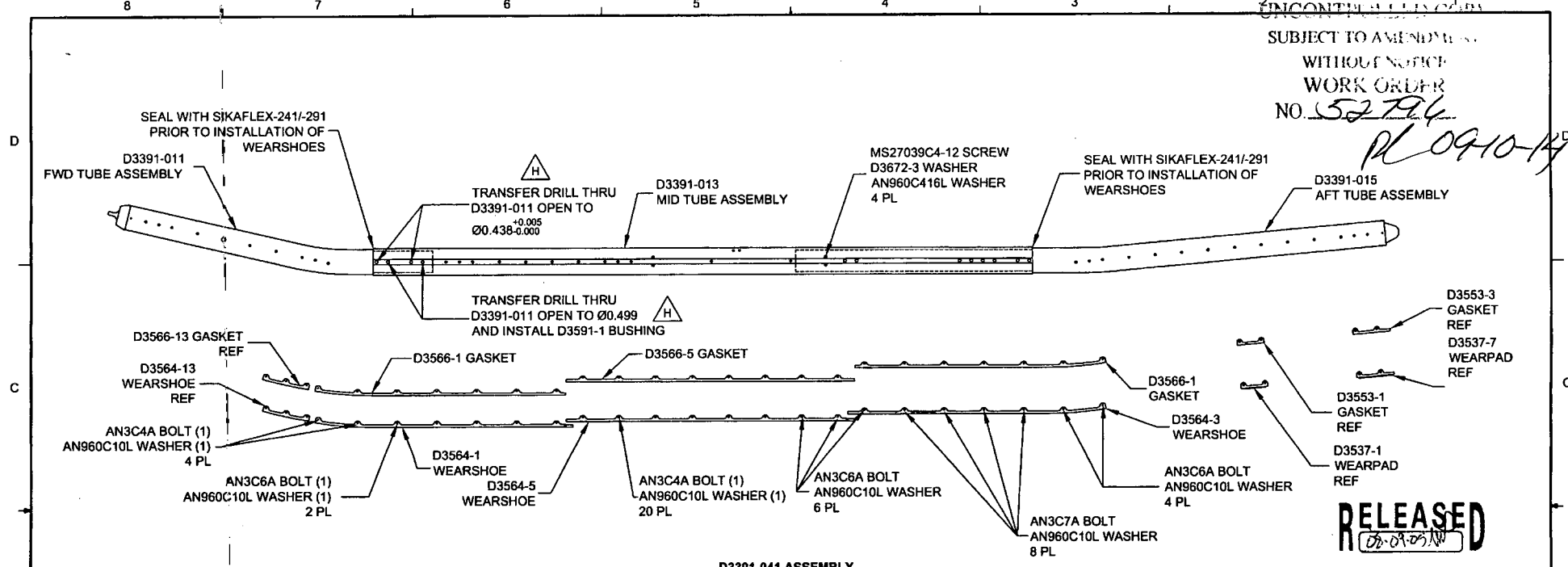
Measured by:	JL	Date:	09/11/16
Audited by:	Q.m	Date:	09/11/18

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52796

PL 0910-14



D3391-041 ASSEMBLY

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

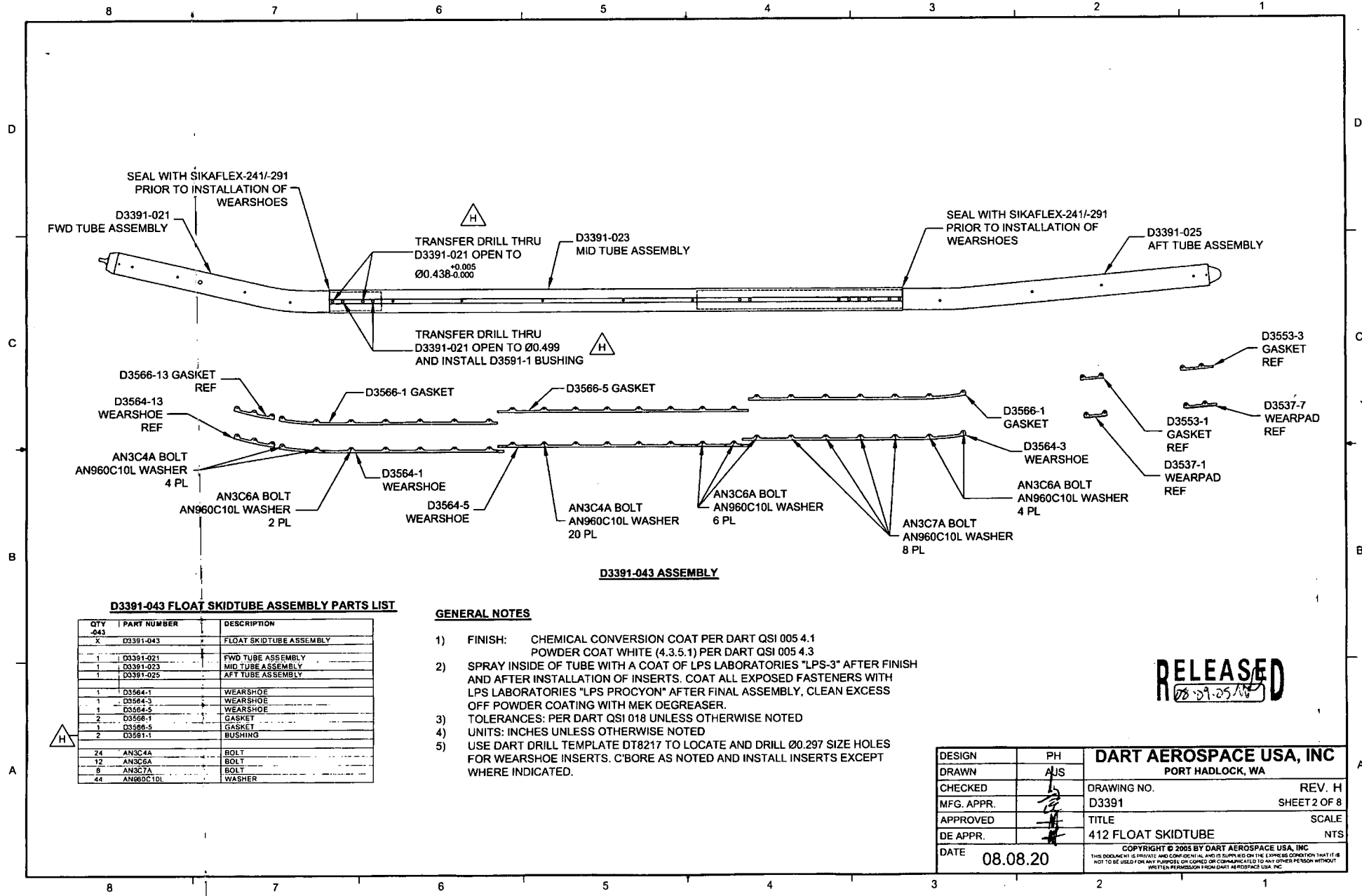
QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. 2N C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. 2N C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O 52794



D3391-043 ASSEMBLY

D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3566-13	BUSHING
24	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER

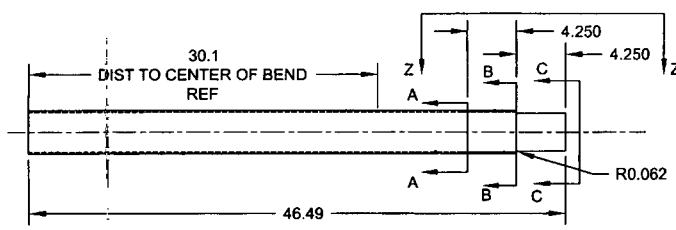
GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

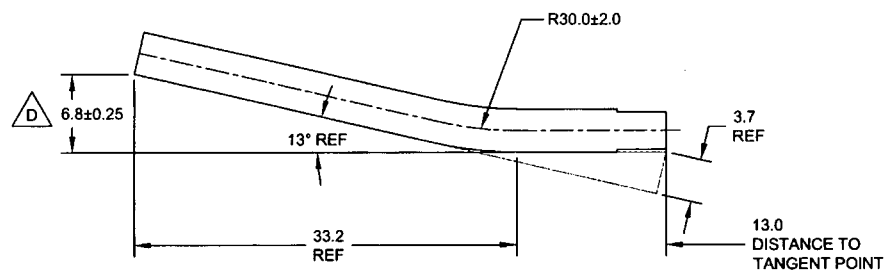
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MFG. APPR.				D3391	SHEET 2 OF 8
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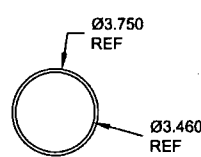
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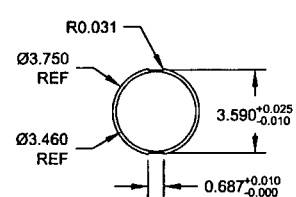
D3391-1 CUTTING DETAIL
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



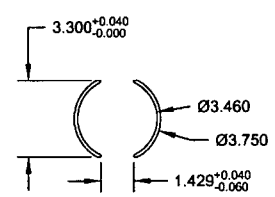
D3391-011/-021 BENDING DETAIL
(MAKE FROM D3391-1)



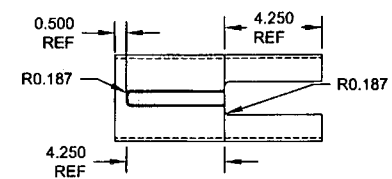
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SCALE 2X



SECTION B-B
SCALE 2X



SECTION C-C
SCALE 2X

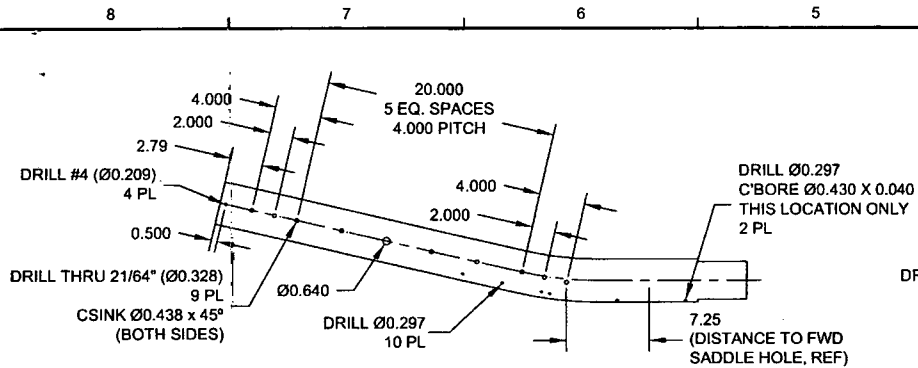


VIEW Z-Z
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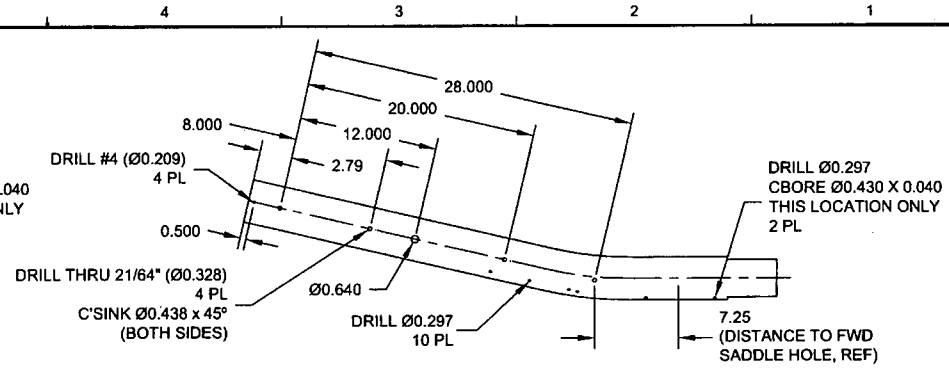
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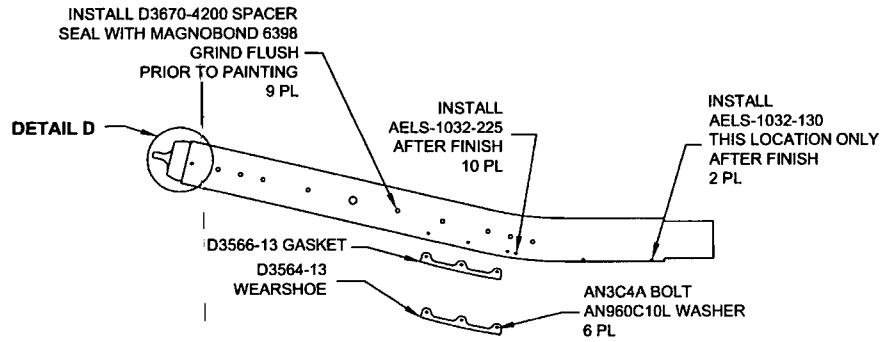
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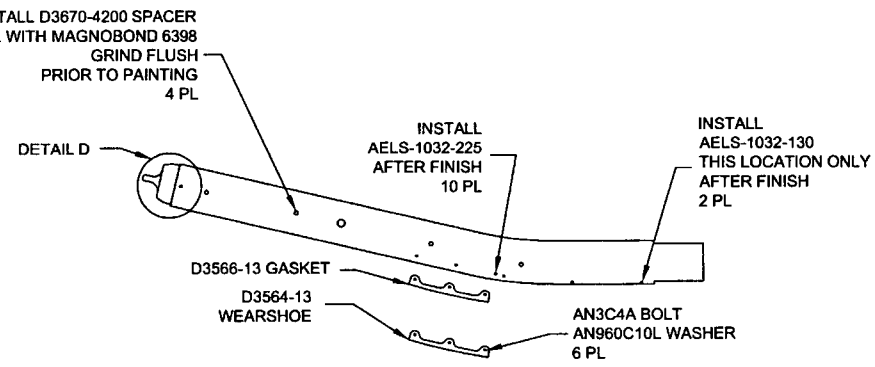
D3391-011 DRILLING DETAIL



D3391-021 DRILLING DETAIL



D3391-011 ASSEMBLY DETAIL

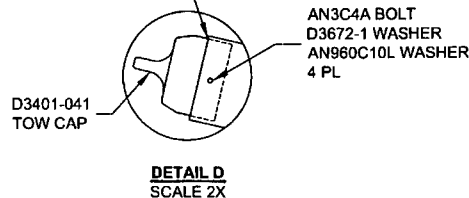


D3391-021 ASSEMBLY DETAIL

D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X	X	D3391-011	FWD TUBE ASSEMBLY
		D3391-021	FWD TUBE ASSEMBLY
1	1	D6013-047	FWD TUBE
1	1	D3401-041	TOW CAP
1	1	D3564-13	WEARSHOE
1	1	D3566-13	GASKET
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
2	2	AELS-1032-130	INSERT
10	10	AELS-1032-225	INSERT

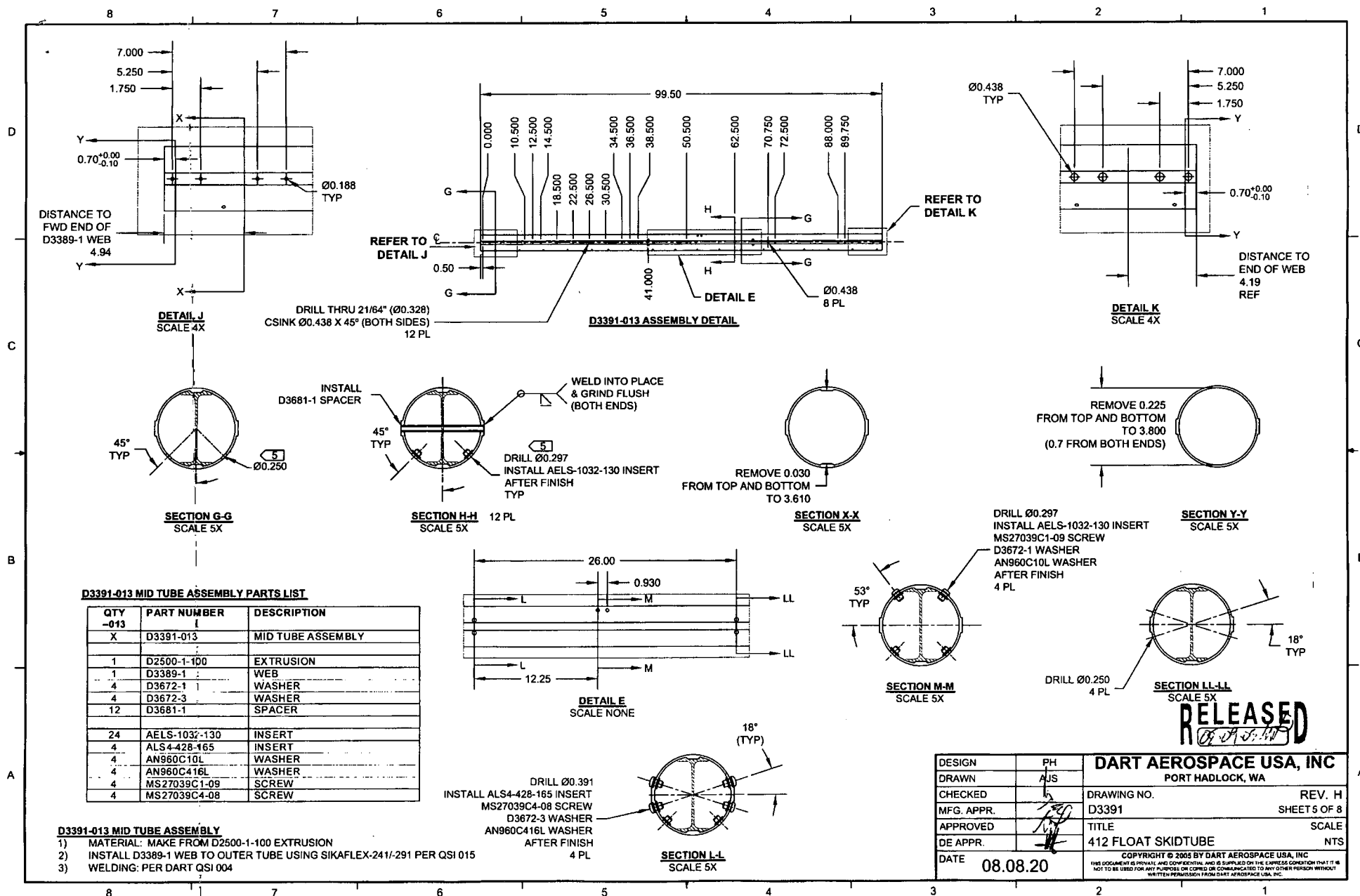
SEAL WITH
SIKAFLEX-241/-291



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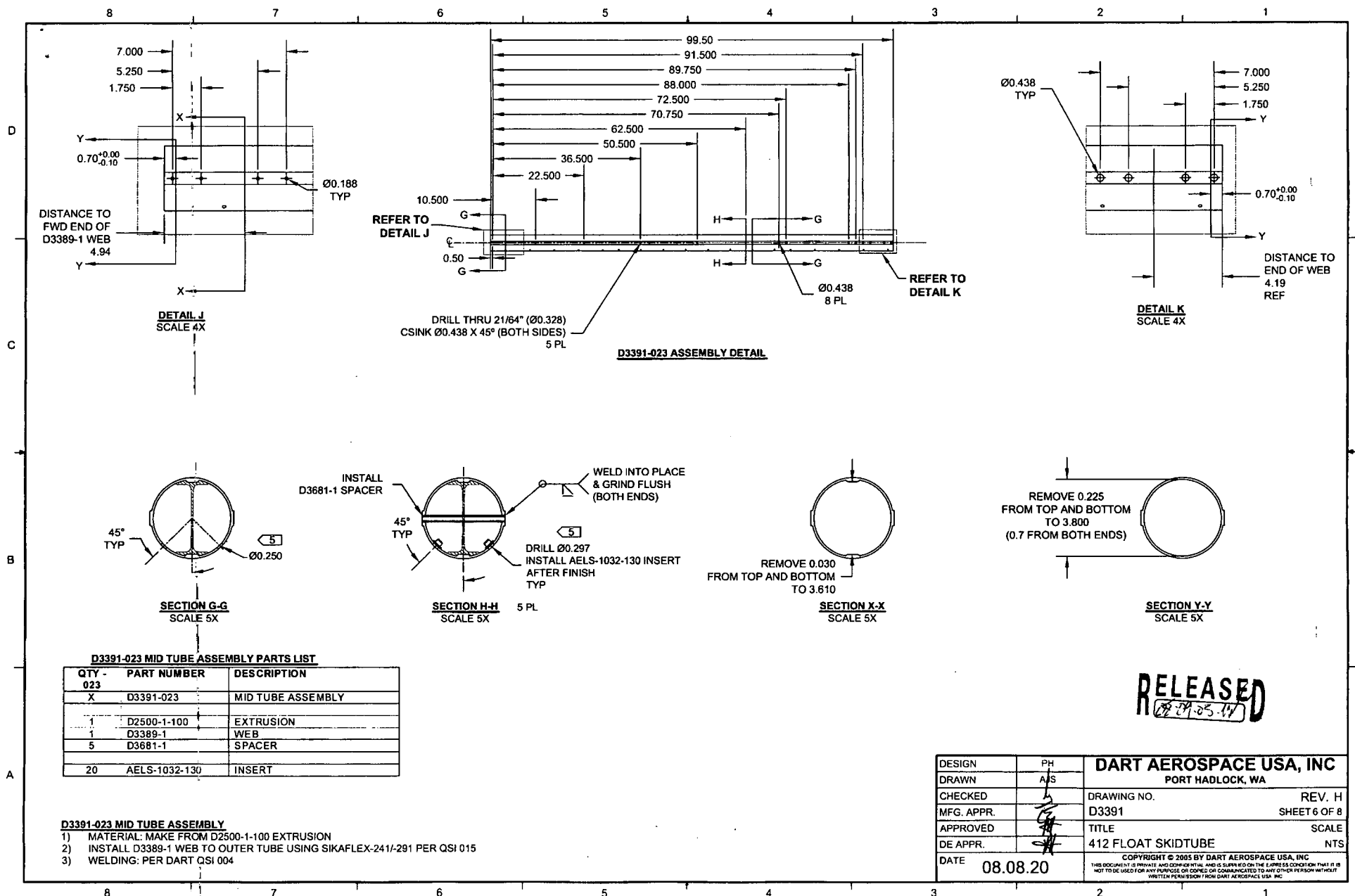
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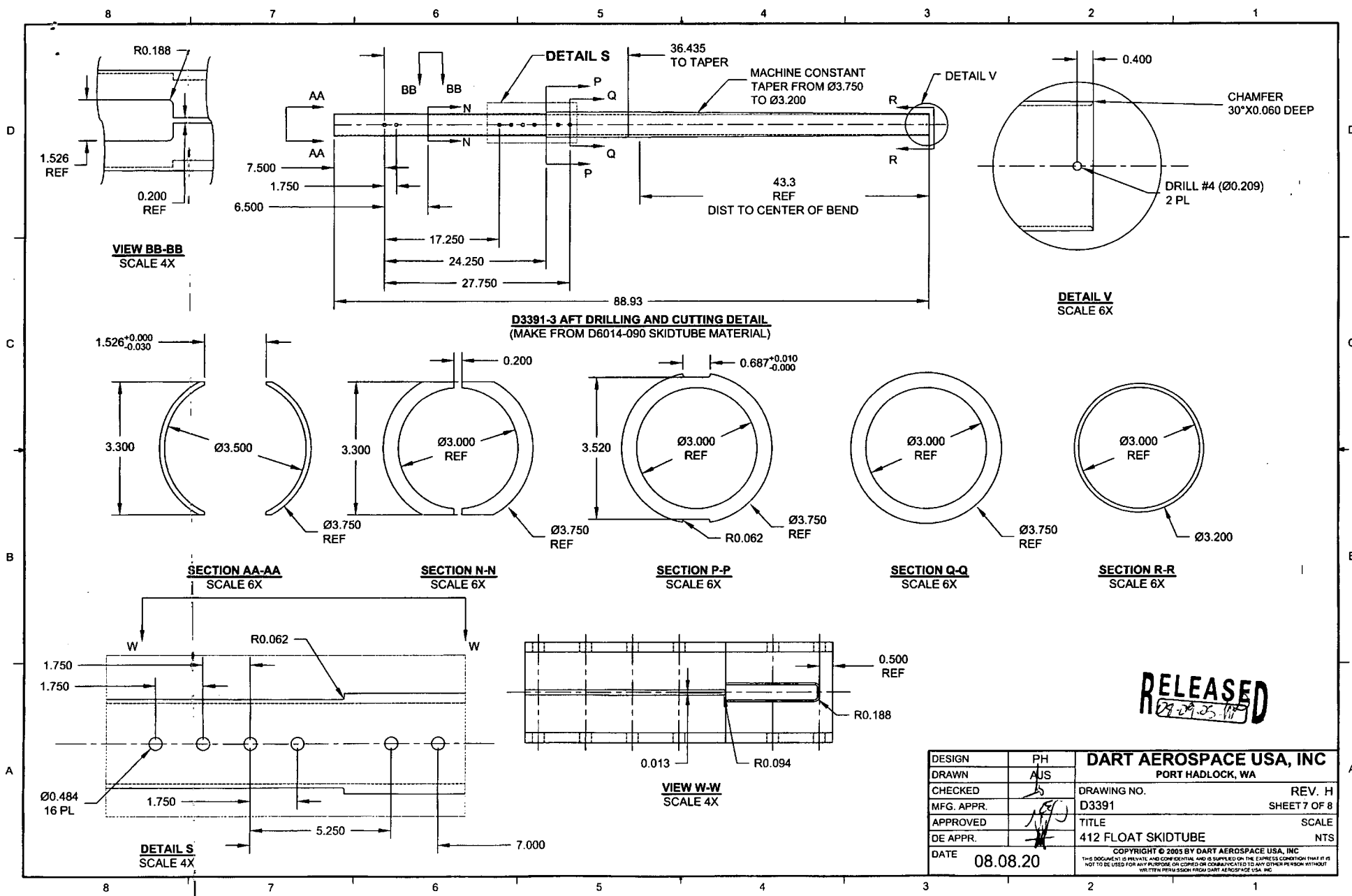
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